: 350 SKIDTUBE EXTRUSION (BENT)

Wednesday, 1/4/2006 7:30:32 AM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 25384

Estimate Number : 10997

P.O. Number

:NIA

This Issue

Prsht Rev.

First Issue

Written By

Previous Run

: 1/4/2006

: NC

: NIA : NIA

Type

: MACHINED PARTS

S.O. No. : NIA

Checked & Approved By

Comment

: Est. B02.11.28 Reformat

: See Comment

Due Date

Part Number

Drawing Name

: D26003BENT

Drawing Number Project Number

. D2600 REV D1 : N/A

Drawing Revision Material

: D1 : NIA

: 1/11/2006

Qty:

50 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D26003BENT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Extrusion Bent

Pick:

Qtv

Part Number

D2600-3 Extrusion

Description

Extrusion Bent

Pm'06-01-06 BENDING MACHINE

Pmc 06-01-06 60

2.0

BENDING



Comment: BENDING MACHINE

Deburr one end of extrusion Drill #30 pilot holes using DT8689 >

Open holes to 5/16" and deburr

Bend using CNC bending machine as per program 2750.C and Folio FT003.

Use 5/16 locator pin on buggy "A".

Check fit to Jig DT8150

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect work to Step 6Ensure fit to Jig DT8150

4.0

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

06-01-17







Pm C06-01-091

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				-			:				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: <u>06/01/1</u>
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	STEP 2	Description of NC Section A I piece scrap-mpt'l CVACLED in bender, and Tiny pir pocket in mat'l seemal to be the problem.		Corrective Action Section B	Verification	Approval	Approval			
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
06.01.16			ayour	Scrap : clestreef, Inspect remaining extrusion for CVACKS after benching.		06.01.16	95 PV2	06.01/6		
				,				,		

NOTE: Date & initial all entries

Date:

Wednesday, 1/4/2006 7:30:32 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 25384

Part Number: D26003BENT

Job Number:

Seq. #:

Machine Or Operation:

Description:

5.0

DC

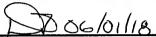
DOCUMENT CONTROL





Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



Dart Ae	rospace	Ltd							
W/O:			V	VORK ORDER CHANGE	S				.
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									:
				95					
				· · · · · · · · · · · · · · · · · · ·					
Part No	•	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
					QA:	N/C Close	d:	_ Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE (NC	R)			
		Description of NC	Corrective Action Section B			Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	
									-
				41					
				/4					

NOTE: Date & initial all entries